

Ship today

Date: Wednesday, 07/11/2007 9:23:40 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 4-MAN SIDE FACING SHOULDER HARNESS KIT,4 POINT /
Job Number : 35598	
Estimate Number : 12184	
P.O. Number :	Part Number : D412702027
This Issue : 07/11/2007 S.O. No. :	Drawing Number : D3196 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 27978	Material :
Written By : <i>[Signature]</i>	Due Date : 07/11/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. A 05.09.01 New issue KJ/JLM Est Rev:B 06.04.03 As per DSI9324 JLM Est Rev:C As per Dsi9351 07-03-14 JLM Est Rev:D 07-07-28 As per Rev E JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

~~Issue Travelers for:~~

Batch

~~D412-702-027 4-Man Side Facing~~

~~Shoulder Harness Kit~~

~~D3446-041~~

~~Harness Assembly~~

N/A *[Signature]*

~~Note: D412-702-027 Kit consists of (1) D3196-3; (1) D3196-4; (4) D3446-041~~

Photocopy bluefile and create labels per PPP D412-702-027CHG001 —

07.11.07 *[Signature]*

2.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 6.1031 f(s)/Unit Total : 6.1031 f(s)

6061-T6 Bar .75" X 1.5"

Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)

(M6061T6B0.750x01.500)

Identify (1) for D3196-3

Identify (1) for D3196-4

Batch: _____

N/A *stk* *W*

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut (2) blanks per (1) D412-702-027 Kit

Cut blanks: (0.75" x 1.50") x 34.750" long Bar

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4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3196-3 as per Folio FA339 and Dwg D3196

Identify as D3196-3

Machine D3196-4 as per Folio FA339 and Dwg D3196

Identify as D3196-4

Deburr

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D3196-3/-4

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

D3196-3/-4

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

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Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D412702069 GROMMET KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GROMMET KIT

Batch:

B34435

AS 07/11/07

12.0 D31963 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bar

Pick: Packing Kit

(Note: D3196-3/-4 are on BOM as material from Steps 3)

Qty Part Number Description Batch

1 D3196-3 Bar

B32136

AS 07/11/07

13.0 D31964 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bar

Qty Part Number Description Batch

1 D3196-4 Bar

B330654

AS 07/11/07

14.0 D3446041 Harness Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Harness Assembly

Qty Part Number Description Batch

4 D3446-041 Harness Assembly

B31469

AS 07/11/07

15.0 D355111 HOOK AND LOOP TIE



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

HOOK AND LOOP TIE

BATCH:

B31217

AS 07/11/07

16.0 MS24694S152 Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Qty Part Number Description Batch

6 MS24694-S152 Screw

M161124

AS 07/11/07

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS24694S154

SCREW



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

SCREW

Batch: M105057

SS 02/11/07

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Parent work is inspect on this step



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/11/07

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-027

Draft 7/11/07 SD (14)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U 07.11.07